

Date: Monday, 3/19/2007 4:38:07 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, INBOARD, RS, 206
 Job Number : 31299
 Estimate Number : 10821
 P.O. Number : N/A Part Number : D26662
 This Issue : 3/19/2007 S.O. No. : N/A Drawing Number : D2666 REV.D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 28604 Material : N/A
 Due Date : 3/30/2007 Qty: 12 Um: Each
 Written By :
 Checked & Approved By : 07.03.20
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house
 processEC
 Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 2X6X6.25

Issue material from stock:

Cut Size 2.0 x 6.25 X 6.0

Grain Along Long 6.0 Length

Batch No: 823934

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1-Inspect part number and batch number are programmed correctly.

3-Fixturing Inspection last completed on N/A by N/A

4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

7- Deburr

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		6.00							

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				
07.03.29	2	6.000 dim is 5.984" Blank cut incorrectly, Qty (1) affected	2 05/04/02	Acceptable per email attached	N/A	2 07/04/05	CP 07.03.29 PR 05/04/02	2 07/04/04	

NOTE: Date & initial all entries

Date: Monday, 3/19/2007 4:38:07 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, INBOARD, RS, 206

Job Number: 31299

Part Number: D26662

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 07.03.30

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL

07/04/02

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/04/02

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 7/4/3

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 7/4/3

(12)

10.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

07/04/05

Job Completion



U 07.04.01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 31299
Description: 206 Saddle, Inboard, Right side	Part Number: D2666-2
Inspection Dwg: D2666 Rev. <i>CD</i>	Page 1 of 1

CS 07.03.20

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.120	0.125	0.121	0.123		
B	0.100	0.140		.137	0.119	0.121	0.124		
C	2.470	2.510		2.493	2.492	2.493	2.496		
D	0.100	0.180		.145	0.140	0.140	0.140		
E	0.210	0.230		.220	0.218	0.219	0.219		
F	1.313	1.343		1.326	1.323	1.321	1.321		
G	0.240	0.260		.252	0.249	0.249	0.250		
H	0.615	0.685		.660	0.660	0.660	0.660		
I	1.125	1.145		1.137	1.133	1.137	1.136		
J	0.990	1.010		1.009	1.008	1.005	1.006		
K	0.235	0.240		.240	0.236	0.237	0.237		
L	0.510	0.515		.512	0.510	0.510	0.510		
M	0.100	0.120		.115	0.115	0.115	0.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.003	6.001	6.002	6.002		
P	1.245	1.255		1.250	1.249	1.246	1.246		
Q	2.495	2.505		2.500	2.500	2.500	2.498		
R	0.490	0.510		.503	0.495	0.498	0.496		
S	0.313	0.318	DT8686	.315	0.315	0.315	0.315		
T	2.495	2.505		2.500	2.498	2.498	2.498		
U	1.357	1.367		1.362	1.360	1.358	1.361		
V	0.315	0.322	DT8686	.321	0.320	0.320	0.320		
W	0.540	0.560		.550	0.543	0.546	0.546		
X	1.674	1.684		1.679	1.676	1.678	1.679		
Y	0.257	0.262	DT8683	.258	0.259	0.259	0.259		
Z	0.178	0.198		.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>BC/En</i>
Date: <i>07/03/29</i>

Audited by: <i>SA</i>
Date: <i>07.03.29</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	<i>[Signature]</i>

DART AEROSPACE LTD	Work Order:	31299
Description: 206 Saddle, Inboard, Right side	Part Number:	D2666-2
Inspection Dwg: D2666 Rev. <u>CD</u>		Page 1 of 1

(b 07.03.20

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 9	2 10	3 11	4 12		
A	0.100	0.140		0.123	0.124	0.123	0.124		
B	0.100	0.140		0.126	0.121	0.121	0.121		
C	2.470	2.510		2.494	2.495	2.494	2.493		
D	0.100	0.180		0.140	0.140	0.140	0.140		
E	0.210	0.230		0.219	0.220	0.221	0.220		
F	1.313	1.343		1.324	1.324	1.324	1.323		
G	0.240	0.260		0.250	0.248	0.251	0.251		
H	0.615	0.685		0.660	0.660	0.660	0.660		
I	1.125	1.145		1.136	1.136	1.137	1.135		
J	0.990	1.010		1.006	1.004	1.006	1.005		
K	0.235	0.240		0.236	0.236	0.236	0.236		
L	0.510	0.515		0.510	0.510	0.510	0.510		
M	0.100	0.120		0.115	0.115	0.115	0.115		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.002	5.988	6.001	6.001		
P	1.245	1.255		1.247	1.248	1.248	1.248		
Q	2.495	2.505		2.501	2.501	2.499	2.499		
R	0.490	0.510		0.499	0.485	0.494	0.496		
S	0.313	0.318	DT8686	0.315	0.315	0.315	0.315		
T	2.495	2.505		2.497	2.503	2.498	2.501		
U	1.357	1.367		1.360	1.360	1.360	1.361		
V	0.315	0.322	DT8686	0.320	0.320	0.320	0.320		
W	0.540	0.560		0.544	0.546	0.546	0.545		
X	1.674	1.684		1.680	1.679	1.681	1.679		
Y	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
Z	0.178	0.188		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
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AF									
AG									
AH									
Accept/Reject									

Measured by:	En
Date:	07/03/29

Audited by:	SA
Date:	07.03.20

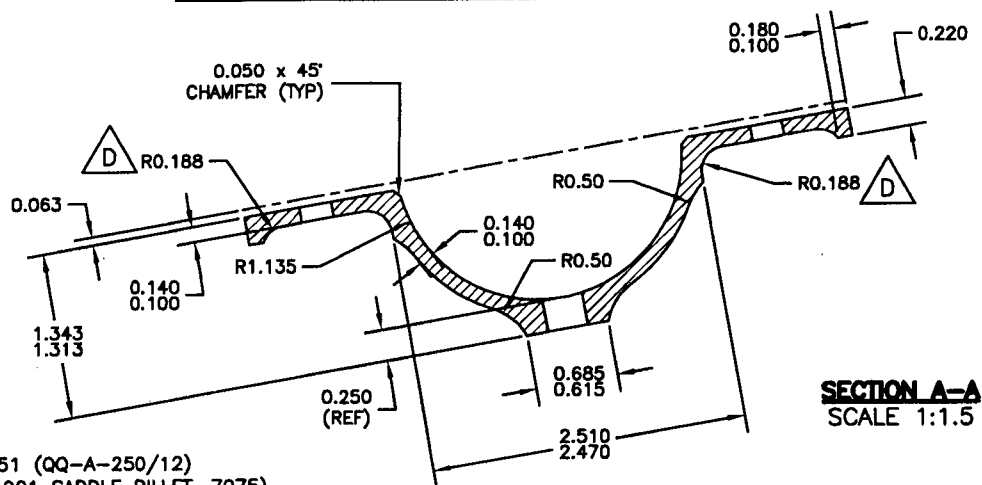
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED #	DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08	TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.26	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

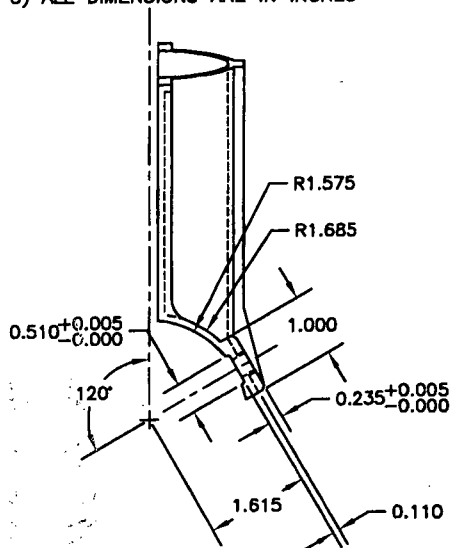
RELEASED

07.02.12 #

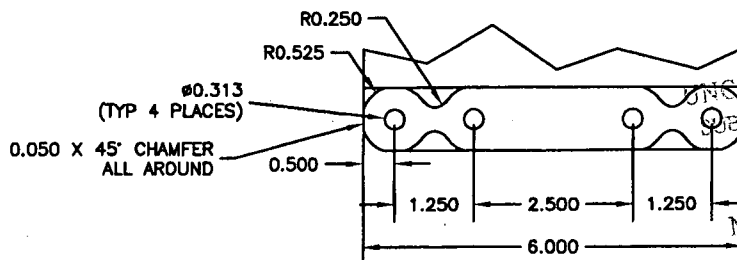
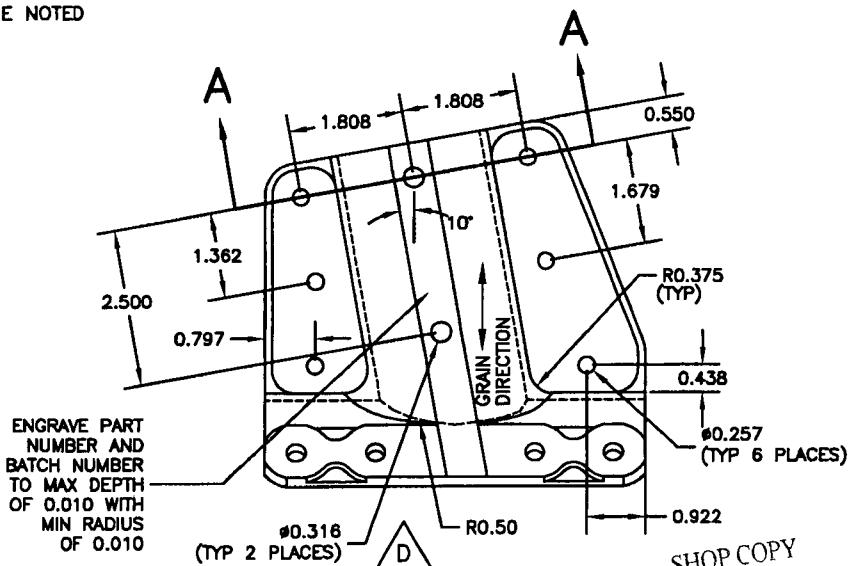


NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



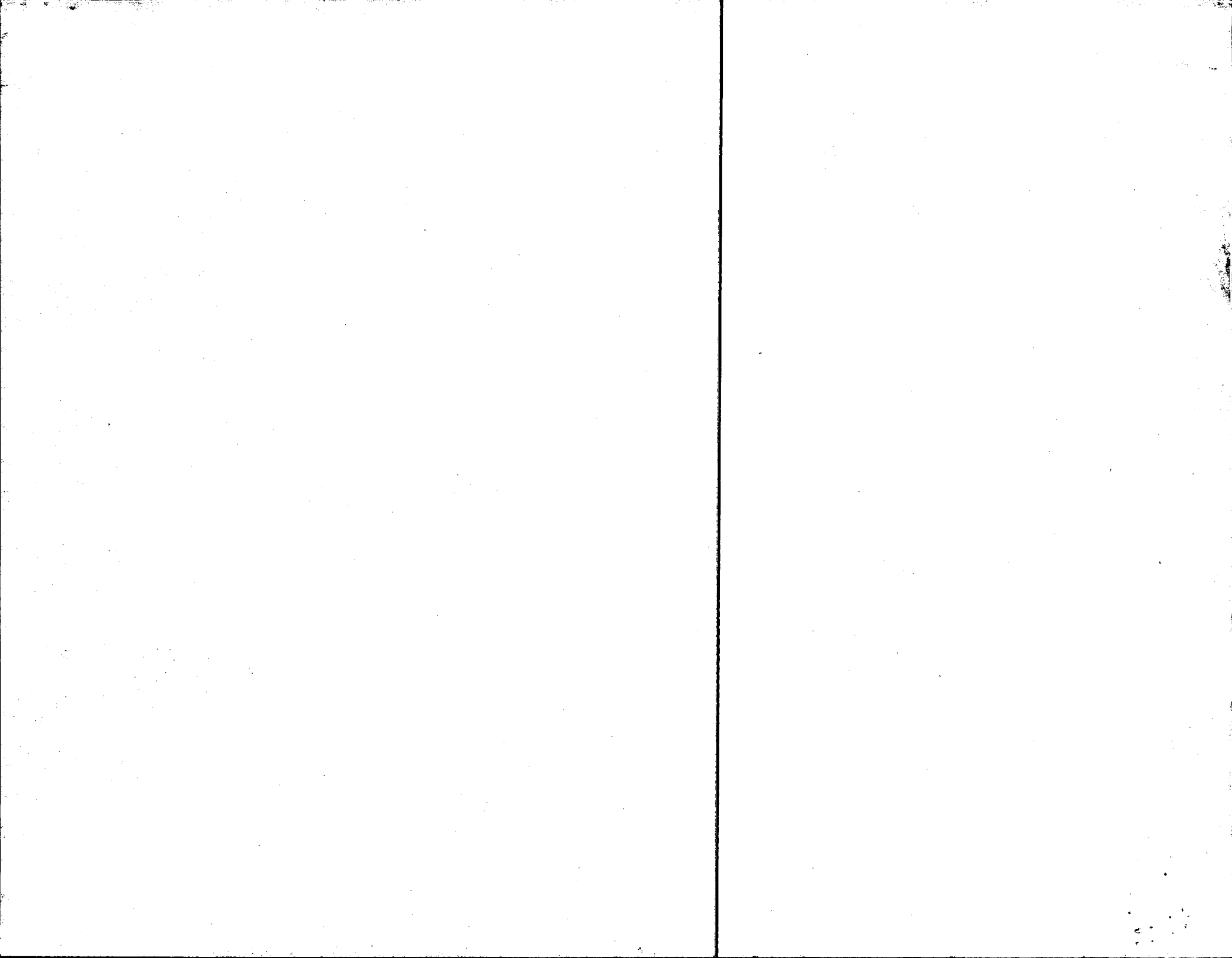
D2666-1 SADDLE FWD INSIDE HIGH



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31299

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Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: March 29, 2007 6:12 PM
To: 'Chris Provencal'
Subject: RE: NCR D2666-2

Acceptable deviation.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, March 29, 2007 1:51 PM
To: David Shepherd (David Shepherd)
Subject: NCR D2666-2

D2666-2

One saddle, the width of the saddle is 5.984" wide instead of 6.000". So the saddle is 0.016" too narrow, or 0.006" under min tolerance. This was due to an error in cutting the blank.

Is this acceptable?

-Chris

--

No virus found in this incoming message.

Checked by AVG Free Edition.

Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007

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No virus found in this outgoing message.

Checked by AVG Free Edition.

Version: 7.1.413 / Virus Database: 268.18.22/739 - Release Date: 3/29/2007

30/03/2007